

Work Order ID 59201

Friday, May 28, 2010 9:17:34 AM



Page 1

Item ID: D3564-9	Accept		Setup Start	
Revision ID:			Stop	
Item Name: Wearshoe				
Start Date: 5/27/2010	Start Qty: 12.00		Cust Item ID:	
Required Date: 6/4/2010	Req'd Qty: 12.00		Customer:	
Reference:				

Approvals:	Process Plan: <u>AL</u>	Date: <u>105-28</u>	Tooling:	Date:	Run Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3564	Rev D								

100	FLOW WATER JET	0.00							
	Waterjet								
	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3564 ***** (D3564-1F) *****								
304 . 063	Rev: <u>D</u> <input type="checkbox"/> 2-Deburr if necessary								

RB 10-6-9

13

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
	Memo	0.00							
Quality Control									

RB 10-6-9

120	QC8- Inspect parts - second check	0.00							
	QC								
	Memo	0.00							
Quality Control									

5010665

13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Page 2

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Setup Start



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Item Name: Wearshoe

Stop



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Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

Debur if necessary ☐ Form on Brake as per Dwg D3564 using Jigs DT 8129 and
DT 8155 ☐ Form Joggle as per Dwg D3564 on brake using Jig DT 8157

SP 10/06/15

(13)

140

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

Ensure joggle as per dwg D3429

S 6/6/14

(X13)

150

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Qty Description Batch ☐ A/R 2059B Hardcoat
☐ Weld hardcoat as per Dwg D3564

M 114642

EL 10-6-15 (X13)

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Page 3

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

3:25

OVEN TEMPERATURE:

FINISH TIME:

3:55

13

10-6-16

W/O:		WORK ORDER CHANGES					
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Page 4

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Customer:

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		41 10/06/16		13	8		
200 Packaging Packaging	Identify as per dwg & Stock Location: <i>FD-19</i> Memo	0.00 0.00				13		BR 10-6-16.	
210 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							10/06/17 <i>MF</i> MF 10-6-17

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Friday, May 28, 2010 9:17:38 AM

Page 1

Work Order ID: 59201



Parent Item: D3564-9



Parent Item Name: Wearshoe

Start Date: 5/27/2010

Required Date: 6/4/2010

Comments: IPP Rev:A New Issue 07-03-08 ec

Start Qty: 12.00

Required Qty: 12.00

IPP Rev:B As per Rev C 07-07-09 JLM

IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date	Status
M304S16GA		Purchased	No			100	sf	6.7443	1.41	17.81053			



304/316 Sheet .063



B10-6-9

Location

Loc Qty

Loc Code

MAT

6.74427

111323

0

114467

6.74427

114799

114799

(13)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	59201
Description: Wearshoe		Part Number:	D3564-9
Inspection Dwg: D3564 Rev: D		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.227	+/-0.010	3.225	*			
2.432	+/-0.010	2.434	*			
2.50	+/-0.030	2.501	*			
6.000	+/-0.010	6.000	X			
12.104	+/-0.010	12.104	✓			
18.000	+/-0.010	18.000	✓			
18.000	+/-0.010	18.000	✓			
18.00	+/-0.030	18.00	✓			
9.00	+/-0.030	9.00	✓			
11.50	+/-0.030	11.50	✓			
0.300 x 0.300	+/-0.010	303 x 304	✓			
Ø0.188	+0.005/-0.001	1191	✓			
R0.375	+/-0.010	1375	✓			
0.063	+/-0.010	1062	✓			

Measured by: IB	Audited by: S	Prototype Approval:	N/A
Date: 10-6-9	Date: 10/06/09	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/EC/DD	DD

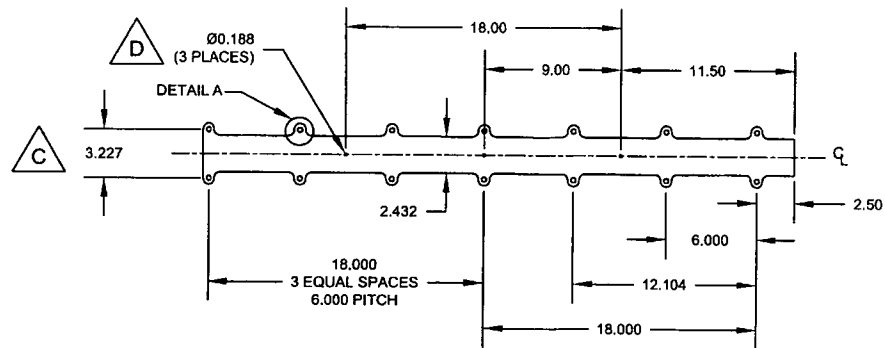
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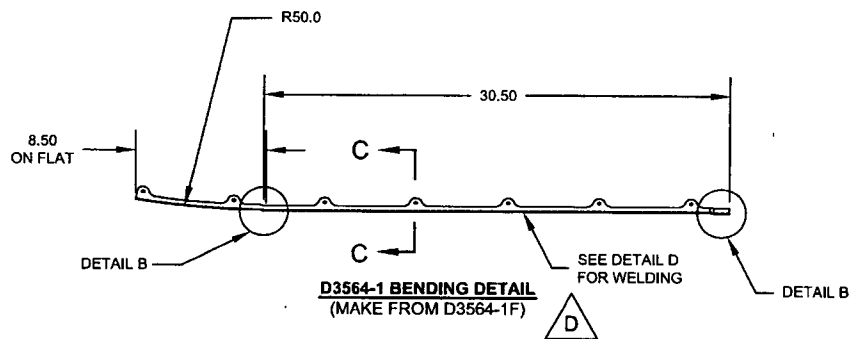
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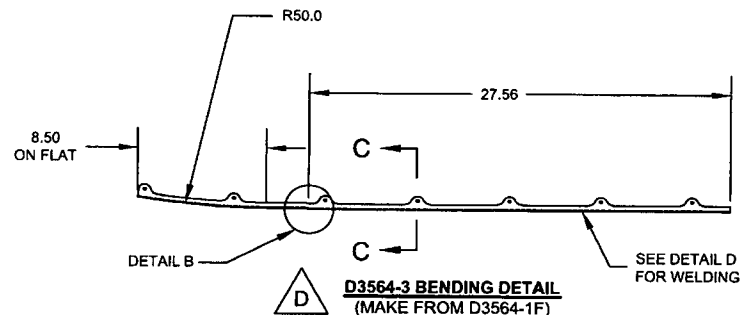
NOTE: Date & initial all entries



D3564-1F FLAT PATTERN



D3564-1 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-3 BENDING DETAIL
(MAKE FROM D3564-1F)

D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT C

WEIGHTS:	
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 59201
B8105-28

RELEASED
07.09.04

D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5,C5: ADD D3564-15; PG1 B6,B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ON PG1; PG3 B8,C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5,7,B2: RELOCATE DETAILS AND SECTION; PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	CB		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	07.08.21		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3564** REV. **D**
SHEET 1 OF 3
TITLE **WEARSHOE** SCALE **1:8**

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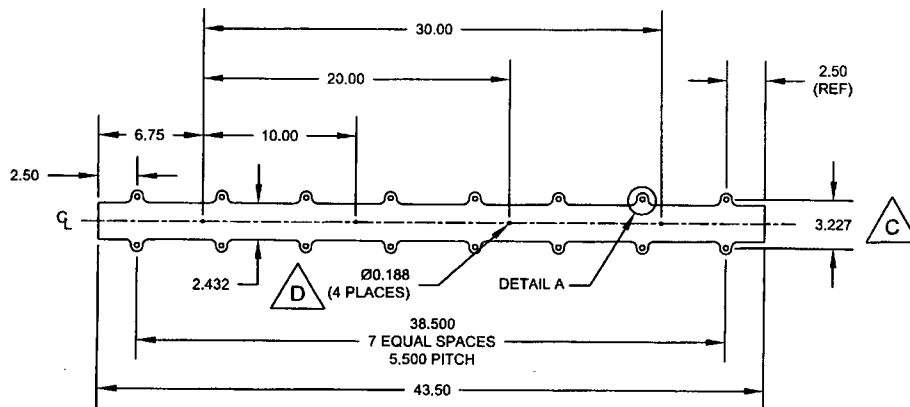
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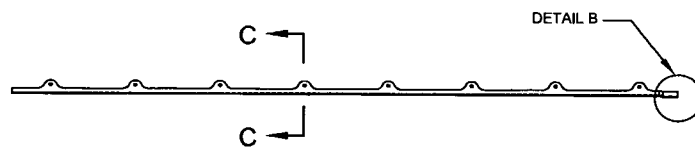
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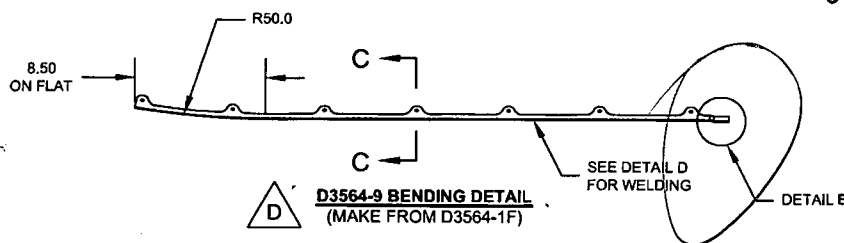
NOTE: Date & initial all entries



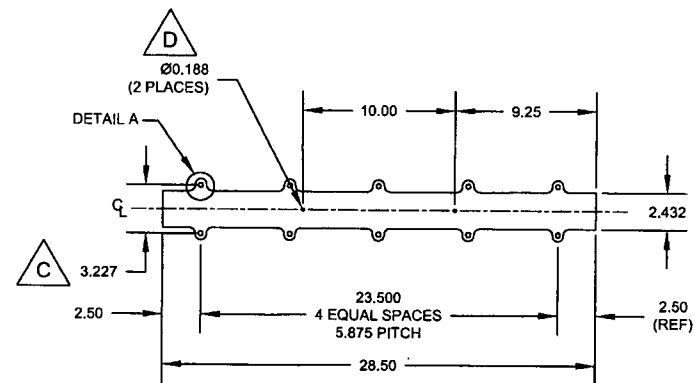
D3564-5F FLAT PATTERN



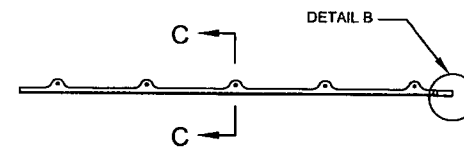
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



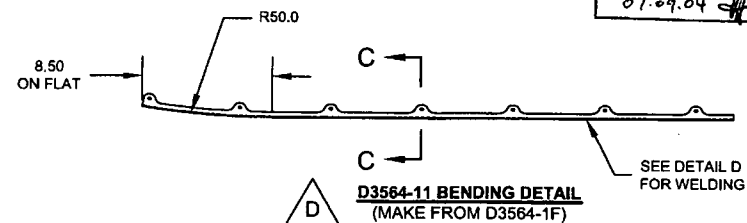
D3564-9 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-7F FLAT PATTERN



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



D3564-11 BENDING DETAIL
(MAKE FROM D3564-1F)

wlo 59201

RELEASED
07-09-04

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB		
CHECKED	PH	DRAWING NO. D3564	REV. D
MFG. APPR.	PH	TITLE WEARSHOE	SHEET 2 OF 3
APPROVED	PH	SCALE 1:8	
DE APPR.	PH		
DATE	07.08.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

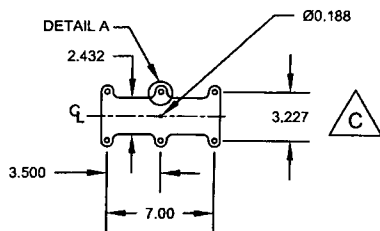
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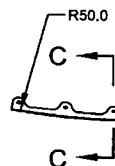
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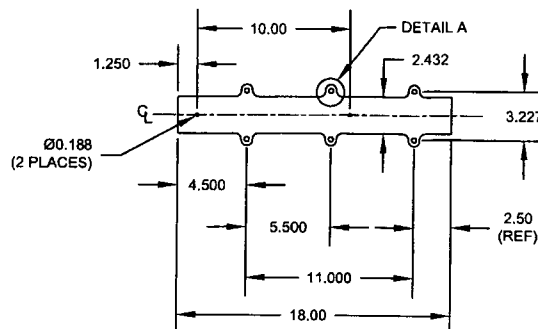
NOTE: Date & initial all entries



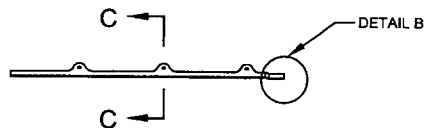
D3564-13F FLAT PATTERN



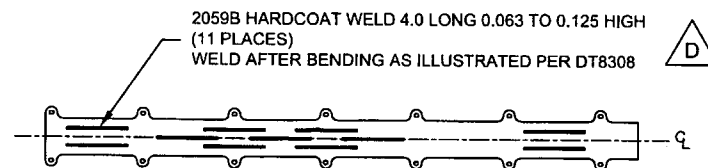
D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



D3564-15F FLAT PATTERN



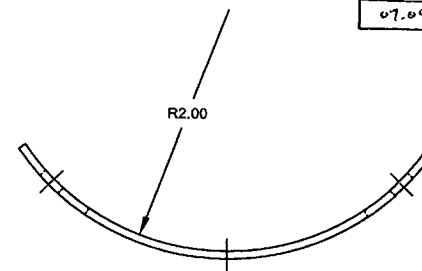
D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)



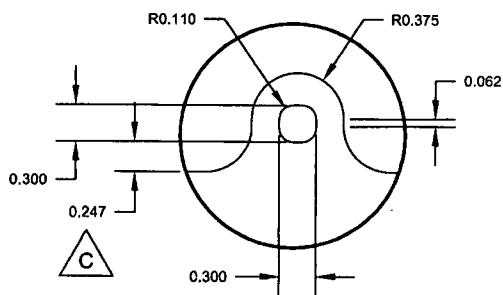
DETAIL D
(D3564-1/-3/-9/-11 WELDING DETAIL)

W/659201

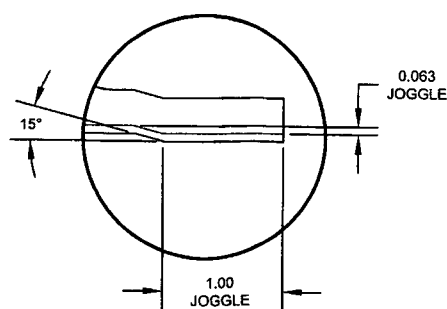
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07.09.04



SECTION C-C
SCALE 1:1



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 3 OF 3
APPROVED	PH	TITLE	SCALE
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